

Date:

Wednesday, 13/12/2006 10:01:18 AM

User:

Linda Lacelle

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

**Drawing Name** 

: LUG

Job Number

**Estimate Number** 

: 29914 : 11066

:HIM

S.O. No. : P/A

**Part Number** 

: D2945

P.O. Number This Issue

: 13/12/2006

**Drawing Number** 

: D2945REV A

Prsht Rev.

: NC : NIP

Project Number

: N/A

First Issue **Previous Run** 

: 29352

**Drawing Revision** 

Material **Due Date**  : 22/12/2006

Qty:

Each 20 Um:

Written By

Checked & Approved By Comment

Added inspect level 8, removed P/O for powder : Est B 00.01.27

: SMALL /MED FAB

coating EC

Est Rev:C Now on Waterjet 06-12-13 JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M6061T6B0187X04000

6061-T6 Bar .178" x 4.0"

Comment: Qty.:

5.9667

0.2712 f(s)/Unit Total: 5.4243 f(s)

6061-T6 Bar .178" x 4.0"

Material: 6061-T6 (QQ-A-250/11)4.00" x 0.188" thick

Batch No. 101417

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2945

Dwg Rev: H Prog Rev:\_\_

Do 12 18

2-Deburr if necessary

3.0





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK







Comment: SECOND CHECK

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Approval	Approval				
DATE STEP		Section A	Initial Action Description Design Mgr Design Mgr		Sign & Date	Section C	Design Mgr	QC Inspector				
06/12/18	ių ·	Uhen cutting on water jet part moved	(S) (O4)	destroy part : veptuse.	e. AV) 26-12:10	06/10/18	PONOUZ	DD 06/12/18				
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Part No:	PAR #:	Fault Category:	NCR:	Yes No	DQA:	Date: <u>67.0:05</u>
NOTE: Date & initial all entries				QA: N/C C	losed:	Date:

Date: Wednesday, 13/12/2006 10:01:19 AM Linda Lacelle User: **Process Sheet Drawing Name: LUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 29914 Part Number: D2945 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 5.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 PACKAGING RESOURCE #1 PACKAGING 1. 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 51 326 9.0 QC21 Comment: FINAL INSPECTION/W/O RELÉASE 6 0 F-01-05 Job Completion

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DATE	STEP	Description of NC Section A	Initial Design Mgr	Corrective Action Section B  Action Description  Design Mgr	Sign & Date		Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No	):	PAR #:	Fault Category	:NCR: \	es No	DOA:		Date:	

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_

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NOTE: Date & initial all entries

Date:

Wednesday, 13/12/2006 9:54:32 AM

User:

Linda Lacelle

## **Process Sheet**

Customer **Job Number**  : CU-DAR001 Dart Helicopters Services

**Drawing Name** 

: LUG

**Estimate Number** 

: 29352 : 11066

P.O. Number

: 13/12/2006

S.O. No. :

Part Number

: D2945

This Issue

: NC

**Drawing Number** 

: D2945REV A

Prsht Rev. First Issue

: 06/11/2006

: MACHINED PARTS Type

Project Number **Drawing Revision**  : N/A : A

**Previous Run** 

Material **Due Date** 

: 15/11/2006

Qty:

Each 20 Um:

Written By Checked & Approved By

Comment

: Est B 00.01.27 Added inspect level 8, removed P/O for powder coating EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6061-T6 Bar .178" x 4.0"

1.0

M6061T6B0187X04000



Comment: Qty.: 0.2712 f(s)/Unit

5.4243 f(s) Total:

6061-T6 Bar .178" x 4.0"

Material: 6061-T6 (QQ-A-250/11)4.00" x 0.188" thick

Batch No.

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 6.200" 2 parts per blank

3.0

HAAS1

HAÁS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING,#1

Machine per folio FA025

Tumble and deburr any rough edges after tumbling

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

## Dart Aerospace Ltd

Ŵ/O:		WORK ORDER CHANGES									
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<u></u>		Description of NC		Corrective Action Section B	<del></del>	Verification	Annroyal	Annescal			
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector			
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Part No:	PAR #:	Fault Category:	 NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	1/C C	losed:	Date:

Date:

Wednesday, 13/12/2006 9:54:33 AM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: LUG** 

Job Number: 29352

Part Number: D2945

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

5.0

SECOND CHECK



Comment: SECOND CHECK

HAND FINISHING RESOURCE #1



6.0

HAND FINISHING1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

QC5 7.0

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Job Completion



Comment: FINAL INSPECTION/W/O RELEASE

Dart A	erospa	ce Ltd							
W/O:			WC	RK ORDER CHANGES	<del></del>			<del></del>	
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NC	R)			
		Description of NC Corrective Action Section B				Verific	ration	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign Date	& Secti	on C	Design Mgr	QC Inspector
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Part No:	PAR #:	Fault Category:	NCR:	Yes No	DQA:	Date:
NOTE: Date & initial all entries				QA: N/C C	losed:	Date:

DART AEROSPACE LTD	Work Order:	29352
Description: Step Mounting Plate	Part Number:	D2945
Inspection Dwg: D2945 Rev: A		Page 1 of 1

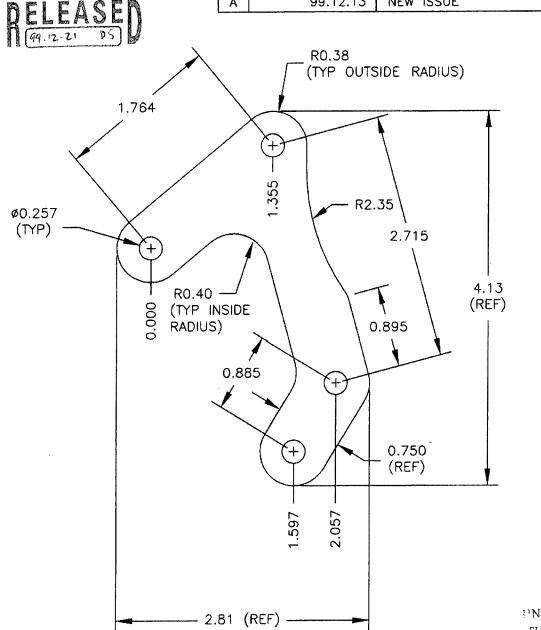
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Rev	Date	Change		Revised by	Approx/ed
Α	05.02.17	New issue		KJ/JLM 🚓	<i>SM</i>





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	DESIGN	CP	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANADA	
	CHECK	ED 🕢	APPROVED ,	DRAWING NO.	REV. A
		#	H	D2945	SHÉET 1 OF 1
ı	DATE			TITLE	SCALE
	99.1	2.13		STEP MOUNTING PLATE	1:1
	Δ		99 12 13	NEW ISSUE	



SHOP COPY RETURN TO ENGINEERING PNCONTROLLED COHY SUBJECT TO AMENDMEN WITHOUT NOTICE

WORK ORDER

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES.